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007008

647.1405  
Job Sheet 186268



Part No: 647.1405

Job Qty: 2 ea

Part Name: EC135 Upper Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/13/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 647.1405 REV D IPP REV:A NEW ISSUE 16-11-15 JLM VERIFIED BY:DD

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off    |
|-------|--------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|-------------|
|       |                    |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |             |
| 90    | Start up Operation | 2 Ea  | 12/14/18   | 12/14/18 | 0.00      | 0.00    | Start Up Stores/Pkg-2 |           | DEC 11 2018 |
| 110   | Packaging          | 2 pcs | 12/14/18   | 12/14/18 | 0.00      | 0.00    | Packaging1-1          |           | DEC 11 2018 |
| 120   | Small Fab          | 2 pcs | 12/14/18   | 12/14/18 | 0.00      | 0.79    | Small Fab-1           |           | DEC 18 2018 |
| 130   | QC                 | 2 pcs | 12/14/18   | 12/14/18 | 0.00      | 0.00    | QC5                   |           | DEC 18 2018 |
| 140   | Packaging          | 2 pcs | 12/14/18   | 12/14/18 | 0.00      | 0.00    | Packaging3-1          |           | DEC 18 2018 |
| 150   | QC21-SA            | 2 Ea  | 12/14/18   | 12/14/18 | 0.00      | 0.00    | QC21                  |           | DEC 18 2018 |

Part Op 120 - Assemble as per dwg and apply locite 598 on all faying surfaces per note 2.  
Descriptions: 140 - \*\*\*IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV\*\*\*

### Job BOM

| Part / Item    | Component Name      | Quantity     | Operation             | Container |
|----------------|---------------------|--------------|-----------------------|-----------|
| 646.9703 013   | Cutter Sub Assembly | 2 Ea (1 ea)  | 90-Start up Operation | 5129005   |
| 647.1514 CK015 | Upper Deflector     | 2 Ea (1 ea)  | 90-Start up Operation | 5129113   |
| MS21042L08     | Nut                 | 6 Ea (3 ea)  | 90-Start up Operation | 5100409   |
| MS27039-08-19  | Screw               | 6 Ea (3 ea)  | 90-Start up Operation | 5104359   |
| NAS1149FN832P  | Washer              | 12 Ea (6 ea) | 90-Start up Operation | 5102796   |

### Job Allocations

| Operation             | Component Part | Required | Inventory | Allocated |
|-----------------------|----------------|----------|-----------|-----------|
| 90-Start up Operation | 646.9703       | 2        | 3         | 0         |
|                       | 647.1514       | 2        | 0         | 0         |
|                       | MS21042L08     | 6        | 1,539     | 0         |
|                       | MS27039-08-19  | 6        | 1,537     | 0         |
|                       | NAS1149FN832P  | 12       | 2,375     | 0         |

### Part Specifications

Specifications could not be found.



DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

|                                                              |                                               |                                        |                                     |                                              |                                      |  |
|--------------------------------------------------------------|-----------------------------------------------|----------------------------------------|-------------------------------------|----------------------------------------------|--------------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b>                            |                                        | <b>AGAINST DEPARTMENT/PROCESS</b>   |                                              |                                      |  |
|                                                              | Rework <input type="checkbox"/>               | Skid-tube <input type="checkbox"/>     | Cross tube <input type="checkbox"/> | Water Jet <input type="checkbox"/>           | Engineering <input type="checkbox"/> |  |
|                                                              | Scrap <input type="checkbox"/>                | Machining <input type="checkbox"/>     | Small Fab <input type="checkbox"/>  | Prod. Eng. Coord. <input type="checkbox"/>   | Quality <input type="checkbox"/>     |  |
|                                                              | Use-as-is <input type="checkbox"/>            | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/>  | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>       |  |
|                                                              | Suspected Unapproved <input type="checkbox"/> | Large Fab <input type="checkbox"/>     | Composite <input type="checkbox"/>  | Supplier <input type="checkbox"/>            |                                      |  |

|        |         |                 |                       |
|--------|---------|-----------------|-----------------------|
| Date : | Step #: | QTY Effective : | MRB (QSI042) Approval |
|--------|---------|-----------------|-----------------------|

|                                                                                                                                                                                      |                                                                                                                                                               |                                                               |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------|
| <b>Description Work Order Deviation</b>                                                                                                                                              | <b>Disposition</b>                                                                                                                                            | <b>Completed By</b>                                           |
| <br><b>Container No: S136940</b><br><br><b>Part: 647.1405</b><br><b>Job No: 186268</b><br><b>Serial No/Batch: S136940</b><br>Revision: D<br>Inspector:<br>Exp Date:<br>Instructions: | Dart Aerospace Ltd.<br>1270 Aberdeen Street<br>Hawkesbury, ON K6A 1K7<br>CANADA<br>TEL.: 1 613 632-5200<br>Email: sales@dartaero.com<br>www.dartaerospace.com | <b>Lead hand / Supervisor</b><br><b>Approval Verification</b> |
|                                                                                                                                                                                      |                                                                                                                                                               |                                                               |
|                                                                                                                                                                                      |                                                                                                                                                               |                                                               |
|                                                                                                                                                                                      |                                                                                                                                                               |                                                               |
|                                                                                                                                                                                      |                                                                                                                                                               | <b>QC / QA Coordinator</b><br><b>Approval</b>                 |

|                                             |                                                |                                                 |                                                            |                                                |                                               |
|---------------------------------------------|------------------------------------------------|-------------------------------------------------|------------------------------------------------------------|------------------------------------------------|-----------------------------------------------|
| <b>Root Cause</b>                           |                                                |                                                 | <b>FAULT CATEGORY</b>                                      |                                                |                                               |
| Environment <input type="checkbox"/>        | No Re-verification <input type="checkbox"/>    | Pressure/Forced <input type="checkbox"/>        | Temperature/Cure <input type="checkbox"/>                  | Power Loss/Surge <input type="checkbox"/>      | Positioned Wrong <input type="checkbox"/>     |
| Design <input type="checkbox"/>             | Operator <input type="checkbox"/>              | Bending <input type="checkbox"/>                | Set-up <input type="checkbox"/>                            | Folio/Program <input type="checkbox"/>         | Outside Dimensions <input type="checkbox"/>   |
| Doc/Data <input type="checkbox"/>           | Offset/Setup <input type="checkbox"/>          | Centre Not Concentric <input type="checkbox"/>  | BOM/Route <input type="checkbox"/>                         | Grain <input type="checkbox"/>                 | Over/Under tolerance <input type="checkbox"/> |
| Equip/Tooling <input type="checkbox"/>      | Supplier <input type="checkbox"/>              | Cracks <input type="checkbox"/>                 | Broken/Damage/Defect <input type="checkbox"/>              | Weld <input type="checkbox"/>                  | Part Incorrect <input type="checkbox"/>       |
| Handling/Pre <input type="checkbox"/>       | Training <input type="checkbox"/>              | Crimp/Kink/Ripple/Wave <input type="checkbox"/> | Inspection Incomplete/Unqualified <input type="checkbox"/> | Wrong Stock Pulled <input type="checkbox"/>    | Part Lost/Missing <input type="checkbox"/>    |
| Material <input type="checkbox"/>           | Use for Testing <input type="checkbox"/>       | Cuffs <input type="checkbox"/>                  | Contamination <input type="checkbox"/>                     | Out of Sequence <input type="checkbox"/>       | Part Moved <input type="checkbox"/>           |
| Internal Transport <input type="checkbox"/> | Poor Information <input type="checkbox"/>      | Crushing <input type="checkbox"/>               | Countersink <input type="checkbox"/>                       | Off-set <input type="checkbox"/>               | Drawing <input type="checkbox"/>              |
| Tribal Knowledge <input type="checkbox"/>   | Rushing <input type="checkbox"/>               | Heat Treat <input type="checkbox"/>             | Cut Too Short <input type="checkbox"/>                     | Mislabeled <input type="checkbox"/>            | Finish <input type="checkbox"/>               |
| LOA <input type="checkbox"/>                | Product Improvement <input type="checkbox"/>   | Wave/Twist in Tube <input type="checkbox"/>     | Instructions Incomplete/Unclear <input type="checkbox"/>   | Fit/Function <input type="checkbox"/>          | Misread <input type="checkbox"/>              |
| Substation <input type="checkbox"/>         | Process Improvement <input type="checkbox"/>   | Marks/Chatter <input type="checkbox"/>          | Drill Holes <input type="checkbox"/>                       | Misaligned/off center <input type="checkbox"/> | Turning Sequence <input type="checkbox"/>     |
| Past Expiry Date <input type="checkbox"/>   | Manufacturing Process <input type="checkbox"/> |                                                 |                                                            |                                                |                                               |
| Misidentified <input type="checkbox"/>      | Past Due <input type="checkbox"/>              | OTHER : _____                                   |                                                            |                                                |                                               |